

Work Order ID 162907

162907

Page 1

Friday, June 16, 2017 8:15:54 AM

Item ID: D4653-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Collar
 Start Date: 6/20/2017 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/6/2017 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: DAS JUN 16 2017 Tooling: Date: Run Start *NR1*
 QC: 21 SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4653	REV A

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.23							
Jeaspa Bandsaw	CUT BLANK AT 3.150"								
105	Hardinge CNC LATHE SMALL	1.57							
105									
Doosan	Memo	1.44							
Doosan Lathe	Machine as per folio FB115								
	FOLIO REV: <u>NA</u>								
	DWG REV: <u>A</u>								
	Deburr								

6 + 2 17-628
 30/17-07-12
 6 + 2 17-628
 PTO

DQA:

Date:

2017-07-25

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>162907</u> Part No. <u>D4653-3</u> NCR No.		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date: <u>17-06-28</u>		Step #: <u>105</u>		QTY Effective: <u>(2)</u>		MRB (QSI042) Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>17-06-28</u>																			
Description Work Order Deviation				Disposition																					
2 parts are scrap dimension $\phi-.812^{+0.001}_{-0}$ are over sized and oval R.C. machine is unable to do round holes and keep tight tolerances -parts will now be sent to HAAS #5 to finish second operation temporary until we get the right size reamer <u>17-06-28</u>				Scrap + replace B137043 Reamer is on order <u>17-06-28</u>																					
				Completed By <u>SL</u> <u>17-6-28</u> Lead hand / Supervisor Approval Verification <u>B.A</u> <u>17-06-28</u> QC / QA Coordinator Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>17-06-28</u>																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	☒ Over/Under tolerance																				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.06		B.A 17-07-12		6	0		DAS 08 9-89
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.12				6	0		DAS 45 9-89 2017-7-18 SVS
121 *121* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.62				(X6)	0		2017/07/19 BETB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		☐ OTHER : _____					

Work Order ID 162907

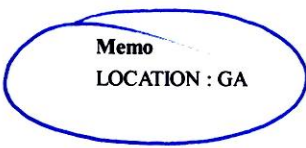
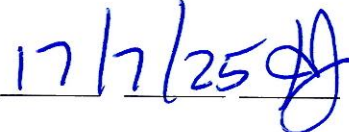
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123 *123* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.06				<u>6</u>			 JUL 18 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ 	0.00 0.06				<u>6</u>			 JUL 24 2017
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.60							  JUL 24 2017

DQA: _____ Date: _____



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OTHER : ☐									

Picklist Print

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Work Order ID: 162907

162907

Parent Item: D4653-3

D4653-3

Parent Item Name: Collar

Start Date: 6/20/2017

Required Date: 7/6/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.250		Purchased				100	f	12.9000	0.25	1.578947			
M6061T6R3 250										**			
6061-T6 RD BAR 3.250"													

Location	Loc Qty	Loc Code
MAT013	12.9	
m131891	0.9	
m137043	12	

135687 ALL

not in system all
material was taken
from stock

2.1

SL 16-6-28

54

DQA: _____ Date: _____



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Work Order update only ☐

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OTHER : ☐									

DQA: _____ Date: _____

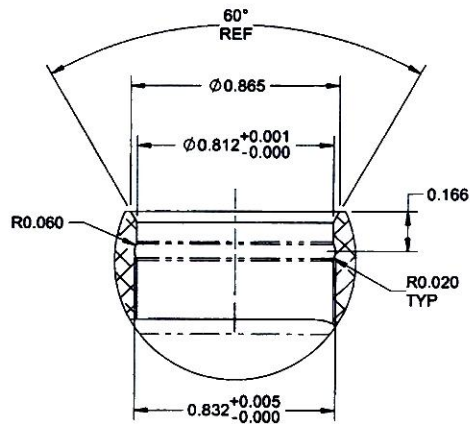
WORK ORDER NON-CONFORMANCE / UPDATE



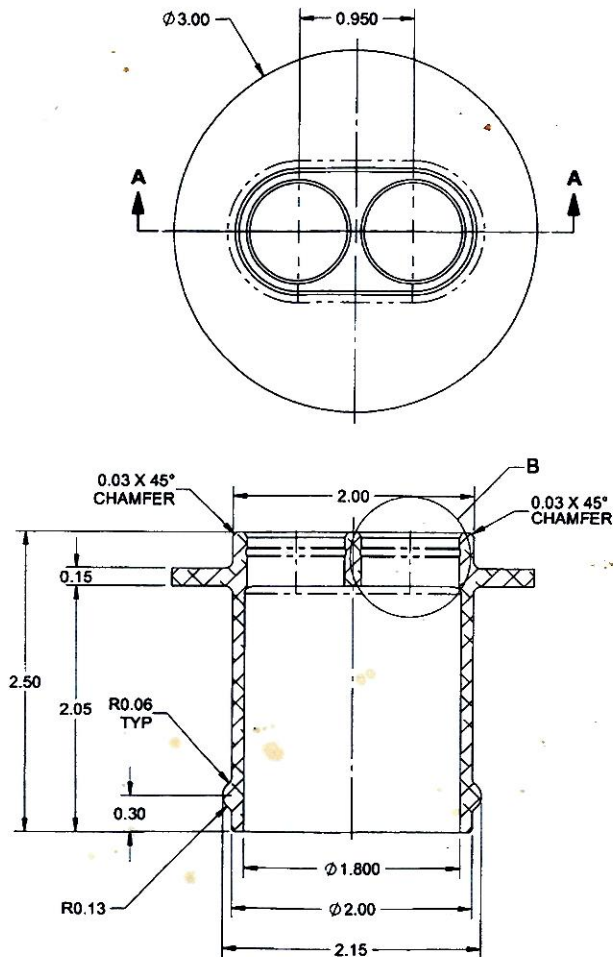
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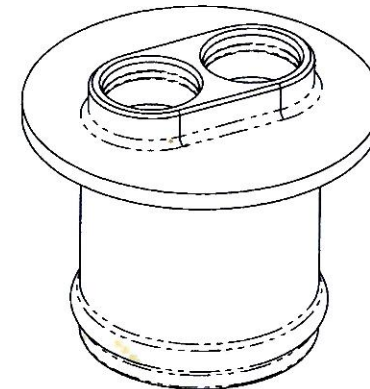
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Misidentified ☐	Past Due ☐																																																																



SECTION B-B
SCALE 2X, 2 PL



SECTION A-A



D4653-3 COLLAR

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.24 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
2012-11-05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4653	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VENT MANIFOLD ASSY	NTS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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